

5/03

DART AEROSPACE LTD	Work Order:	22074
Description: Bracket	Part Number:	D3207-5
Dwg: D3207 Rev. A	Qty:	25
		Page 1 of 1






Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 5. Dwg not required	PA	04.12.08	4
2	MV	Cut blank: 3.260" x 2.956" grain along 2.956" M15120 Material: 6061-T6 (QQ-A-250/11) 0.125" thick M11946 (M6061T6S.125) Identify for D3207-5 Batch: M5720	SD EP	04/12/10	30
3	MV	Machine D3207-5 as per Folio FA396 and Dwg D3207 Stack of 5 Identify as D3207-5	EP	05/01/20	25
4	QC2	Inspect parts as they come off the CNC machine	EP	05/01/20	25
5	QC8	Second check	EP	05/01/20	25
6	GA	Deburr Stack	J	05-01-24	25
7	GB	Form as per Dwg D3207	J	05-01-25	25
8	QC5	Inspect work to Step 7	MS	05-01-25	25
9	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	05/01/25	25
10	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	MM	05/01/26	25
11	QC3	Inspect Powder Coat	CL	05/01/27	25
12	ST	Identify and Stock	CL	05/01/27	25
13	AC	Cost / part <u>8.74</u>	Sgs	05.01.28	25
14	DC	Close W/O <u>8.74</u> Inspect Level 21	J	05.02.02	25


Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	RF

RELEASED

RF 04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/01/20	#3	first run scrap. one stack (five parts) moved on table	 05-05-14-2	destroy & replace	 05/01/31	 0501-31	 0501-31	 0501-31

Part No: D3207-5 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/01/20

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022074
Project Name : D3207-5
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3207-5
Description : Bracket
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 12-06-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

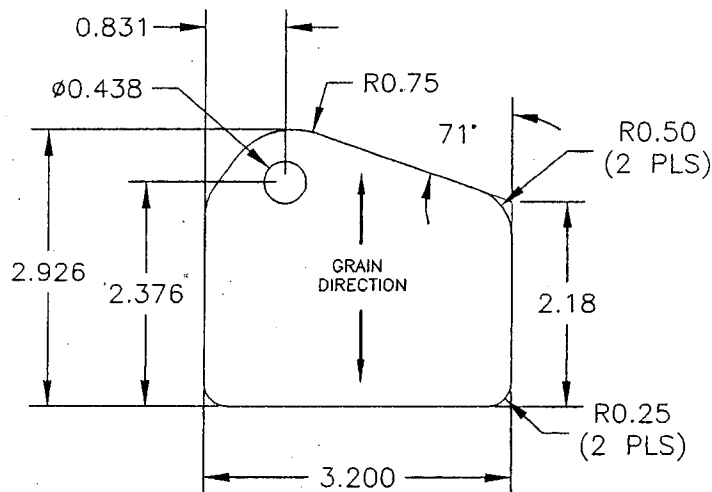
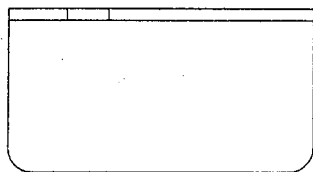
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



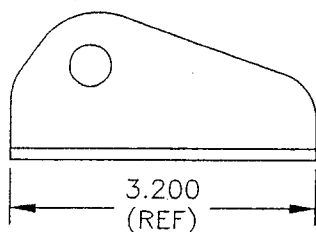
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3207	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

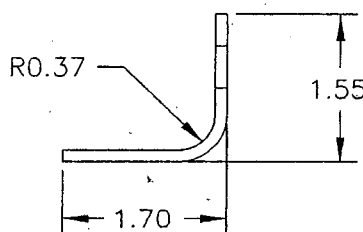
RELEASED
04.04.05



D3207-5 FLAT PATTERN



D3207-5 BEND DETAIL



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SUBJECT TO AMENDMENT
WITHOUT NOTICE**

WORK ORDER

NO. 22074

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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